

Date: Monday, 04/05/2009 1:45:51 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 A/B LOW GEAR WEB		
Job Number	: 47680					
Estimate Number	: 11768					
P.O. Number	:			Part Number	: D26541	
This Issue	: 04/05/2009		S.O. No. :	Drawing Number	: D2654 REVE1	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: E1	
Previous Run	: 46636			Material	:	
Written By	:			Due Date	: 10/05/2009	
Checked & Approved By	: <u>JUL 09.05.09</u>			Qty:	2 Um: Each	
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM Est Rev:E 08-06-10 revE1 as per dwg DD verified by:EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26005108	Extrusion 'I Beam' thin	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
	Qty	Part Number	Description
	1	D2600-5	Web
			<u>Batch</u> <u>1-38589</u> <u>M6 09-05-07</u>
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1	
		1-Cut D2600-5 to length as per Dwg D2654 (73.85")	
		2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654	
		3-Using the uni-bit, open holes to finish size as per Dwg D2654	
		4-Deburr holes and ends	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1	
		Acid etch and Alodine as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B LOW GEAR WEB

Job Number: 47680

Part Number: D26541

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



x2

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AT 09-09-07

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Skid tube cell

13 09-05-07 (2)

7.0 QC21 FINAL INSPECTION/W/O RELEASE



09/05/07 JY

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DEO ATTACHED**



DESIGN <i>GP</i>	DRAWN BY <i>GP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D2654	REV. E SHEET 1 OF 2	
DATE 04.05.26		TITLE WEB	SCALE 1:20	
A	97.03.25	NEW ISSUE		
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438		
C	97.10.29	CHANGED HOLE PATTERN		
D	98.01.15	GHW HOLES CHANGED TO $\varnothing 0.63$		
E	04.05.26	CHANGE LENGTHS, REFORMAT		
E1	<i>GP</i> 04.08.34	PER TOOLING; 80.8 WAS 80.5		

Technical drawing showing a vertical profile with various dimensions and a callout to Detail A.

Dimensions (from top to bottom):

- 0.00
- 1.50
- 6.50
- 11.50
- 18.00
- 26.72
- 34.45
- 42.18
- 49.90
- 57.53
- 65.35
- 73.8

Callout to Detail A:

- SEE DETAIL A
- 0.500
- 16 PLACES

Bottom detail dimensions:

- 5.000
- 3.750
- 1.250

Detail A Scale: 1:10

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 111080

MAKE FROM D2600-5-108 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

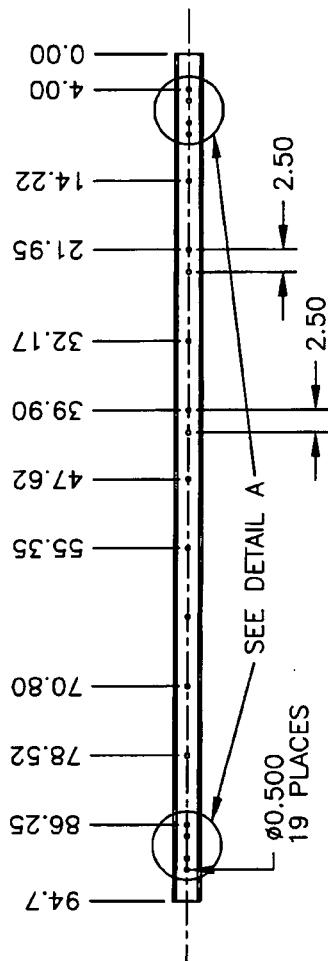
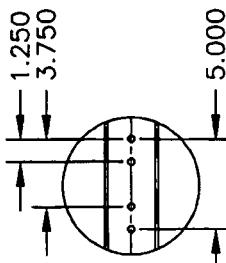
**DART**DRAFT COPY  
SHEET 1 OF 2

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654 REV. E
DATE 04.05.26		SHEET 2 OF 2 TITLE WEB SCALE 1:20

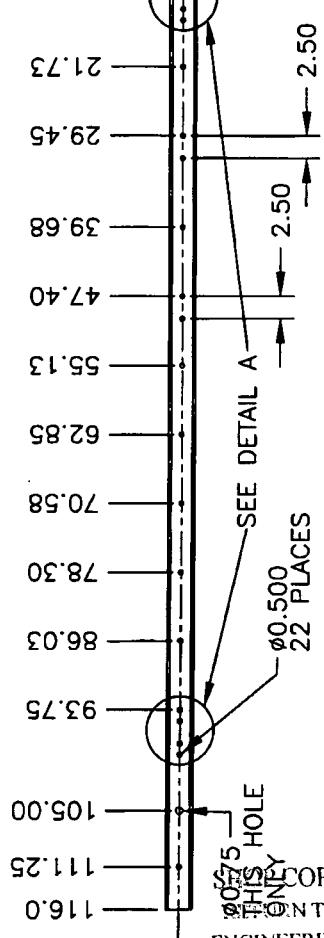
RELEASED  
04.06.22

DEO ATTACHED

D2654-5 WEB

DETAIL A  
SCALE 1:10

D2654-7 WEB



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WORK ORDER  
NO. 47680

MAKE FROM D2600-7-125 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

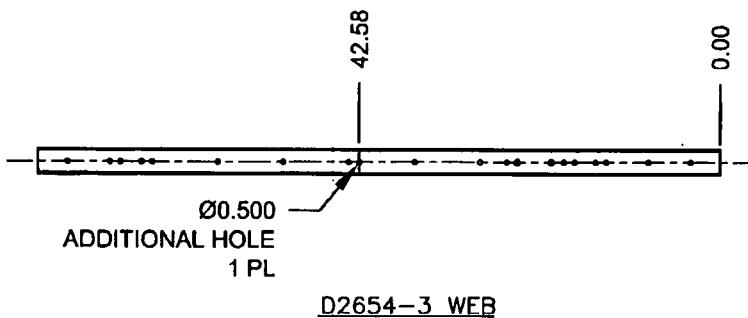
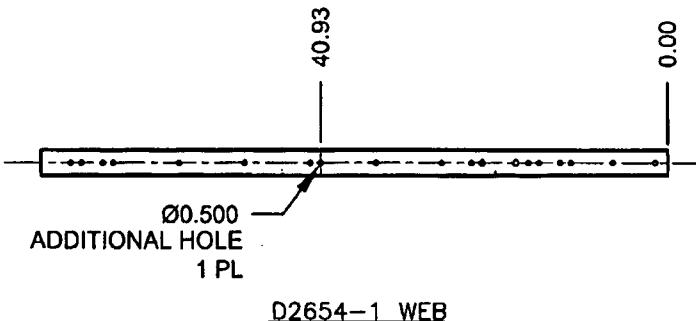
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DRAWING NO. D2654	TITLE WEB	REV. E1	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D2654-E-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>PA</i>	MFG. APPR. <i>CE</i>	APPROVED <i>1ND</i>	DE APPR. <i>1</i>			
DATE 09.03.11	DATE 09.03.11	DATE 09.04.03	DATE 09.04.03	DATE 09.04.03	DATE 09.04.03		

DRILL AN ADDITIONAL HOLE IN THE D2654-1 AND D2654-3 WEB AT THE LOCATION INDICATED:

**RELEASED**  
*09/04/08 MJD*



THE ADDITIONAL HOLE IS REQUIRED FOR COMPATIBILITY WITH D3804-041/-043 SKIDTUBE ASSEMBLIES. ALL OTHER INFORMATION REMAINS UNCHANGED.

WORK ORDER  
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